

Split

Dart Aerospace Ltd.

Date: Wednesday, 12/14/2005 3:56:58 PM  
User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BEARING ASSEMBLY
Job Number	: 25225-2		
Estimate Number	: 10716		
P.O. Number	: N/A	Part Number	: D3121241
This Issue	: 12/14/2005 S.O. No. : N/A	Drawing Number	: D3121 REV C2
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: C2
Previous Run	: 24777	Material	: N/A
Written By	: SEE COMMENT BELOW	Due Date	: 12/21/2005
Checked & Approved By	: SEE COMMENT BELOW	Qty:	79 -20 Um: Each
Comment	: Est Rev:A 04.02.18 New issue KJ/DS		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MDELNR12500	DELIN ROUND BAR 1.25"
-----	-------------	-----------------------



Comment: Qty.: 0.0431 f(s)/Unit Total : 0.8610 f(s)  
Material: Ø1.25 Delrin Rod  
(M-DELIN-R1.2500) Identify as D3121-25  
Batch: M16128

M8 0512121

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL

1-Turn D3121-25 Cap as per Folio FA387

→ M8 0512121

79

2-Deburr

→ M8 0512121

79

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

M8 0512121

79

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

→ M8 0512121

79

5.0	D312123	Bearing
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

DL 06/01/24

Pick:

Qty Part Number

Description Batch

1 D3121-23

Bearing

B25432 X 29

B25340 (40x)

DL 06/01/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA:   *SD*   Date:   06/01/23  

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<i>X</i>								

NOTE: Date & initial all entries

Date: Wednesday, 12/14/2005 3:56:56 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARING ASSEMBLY

Job Number: 25225

Part Number: D3121241

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Press D3121-23 Bearing into D3121-25 Cap as per Dwg D3121

DL 06/01/24 (29)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Job 01-24 25

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: 401

06/01/24 (29)

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

545 06/01/25 (29) 06/01/25 (29)

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

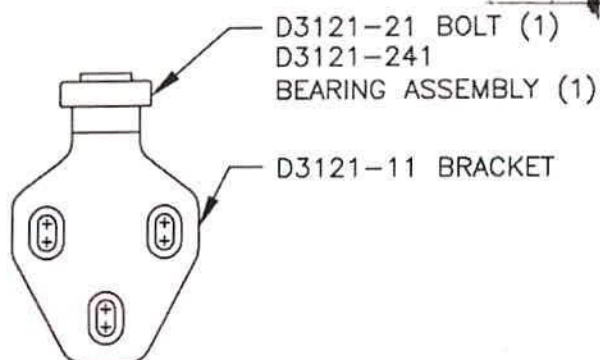
NOTE: Date & initial all entries





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CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D3121	REV. C SHEET 1 OF 10
DATE	04.02.17		TITLE	BRACKET ASSEMBLY	SCALE 1:2
A	02.04.15	NEW ISSUE			
B	03.01.16	ADD RIDGES; ADD MAT'L PROP; FIX P/N ADD -141/-143/-144/-145/-146			
C	04.02.17	ADD CLEARANCE; USE -241 BEARING			
C1	<i>[Signature]</i> 04.03.26	3.17 WAS 4.00; 6.11 WAS 6.14			
C2	<i>[Signature]</i> 04.04.26	0.230 WAS 0.235			

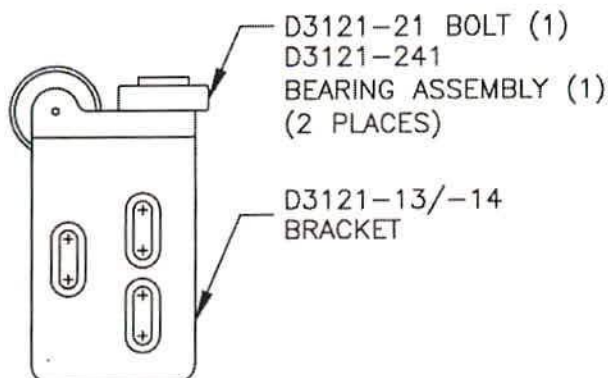
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04-03-01 *[Signature]*



D3121-21 BOLT (1)  
D3121-241  
BEARING ASSEMBLY (1)

D3121-11 BRACKET

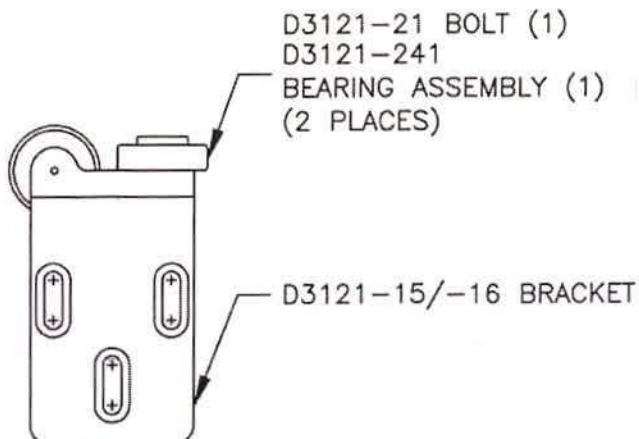
**D3121-041 BRACKET ASSEMBLY**  
(REPLACES PREMIER P/N B30-23000-33)



D3121-21 BOLT (1)  
D3121-241  
BEARING ASSEMBLY (1)  
(2 PLACES)

D3121-13/-14  
BRACKET

**D3121-043 (SHOWN) / D3121-044 (OPPOSITE)  
BRACKET ASSEMBLY**  
(REPLACES PREMIER P/N B30-23000-37/-38)



D3121-21 BOLT (1)  
D3121-241  
BEARING ASSEMBLY (1)  
(2 PLACES)

D3121-15/-16 BRACKET

**D3121-045 (SHOWN) / D3121-046 (OPPOSITE)  
BRACKET ASSEMBLY**  
(REPLACES PREMIER P/N B30-23000-35/-36)

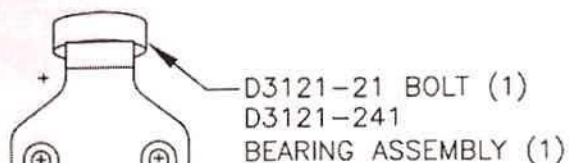
25225

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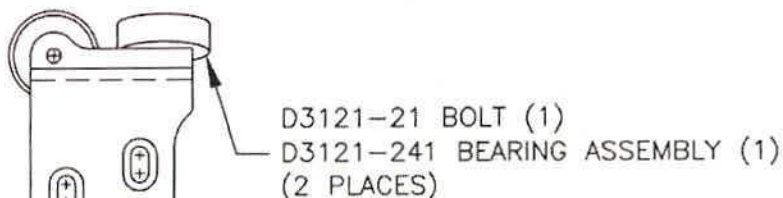


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DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:2



D3121-111 BRACKET

**D3121-141 BRACKET ASSEMBLY**  
(REPLACES PREMIER P/N B30-23001-01)



D3121-113/-114 BRACKET

**D3121-143 (SHOWN) / D3121-144 (OPPOSITE) BRACKET ASSEMBLY**  
(REPLACES PREMIER P/N B30-23000-03/-04)



D3121-115/-116 BRACKET

**D3121-145 (SHOWN) / D3121-146 (OPPOSITE) BRACKET ASSEMBLY**  
(REPLACES PREMIER P/N B30-23000-05/-06)

WORK ORDER  
NO 25225

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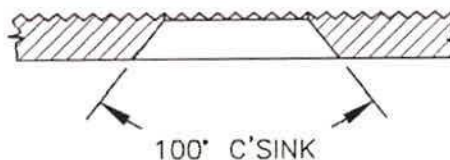
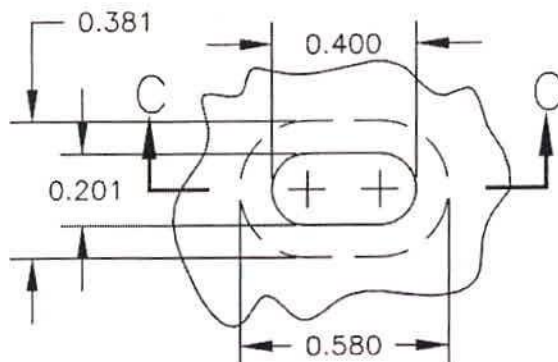
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DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:1

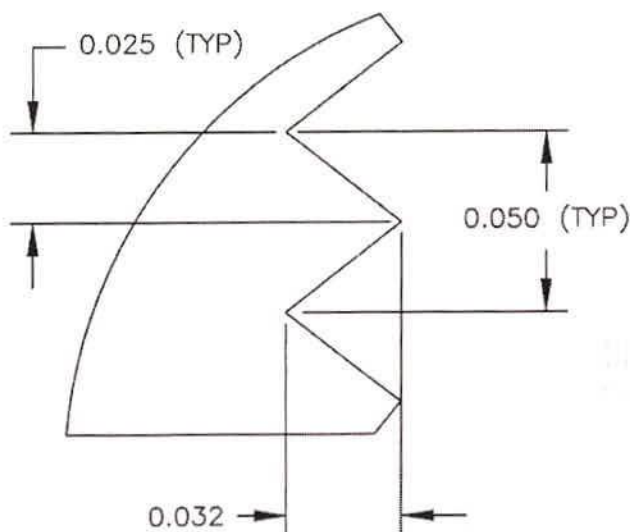
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04.03.01 #

**DETAIL A:**  
**SLOT DETAIL**  
SCALE 2:1  
VIEW ROTATED



**SECTION**  
**C-C**

**DETAIL B:**  
**RIDGE DETAIL**  
PARTIAL SECTION  
SCALE 1:20



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NO. 25225

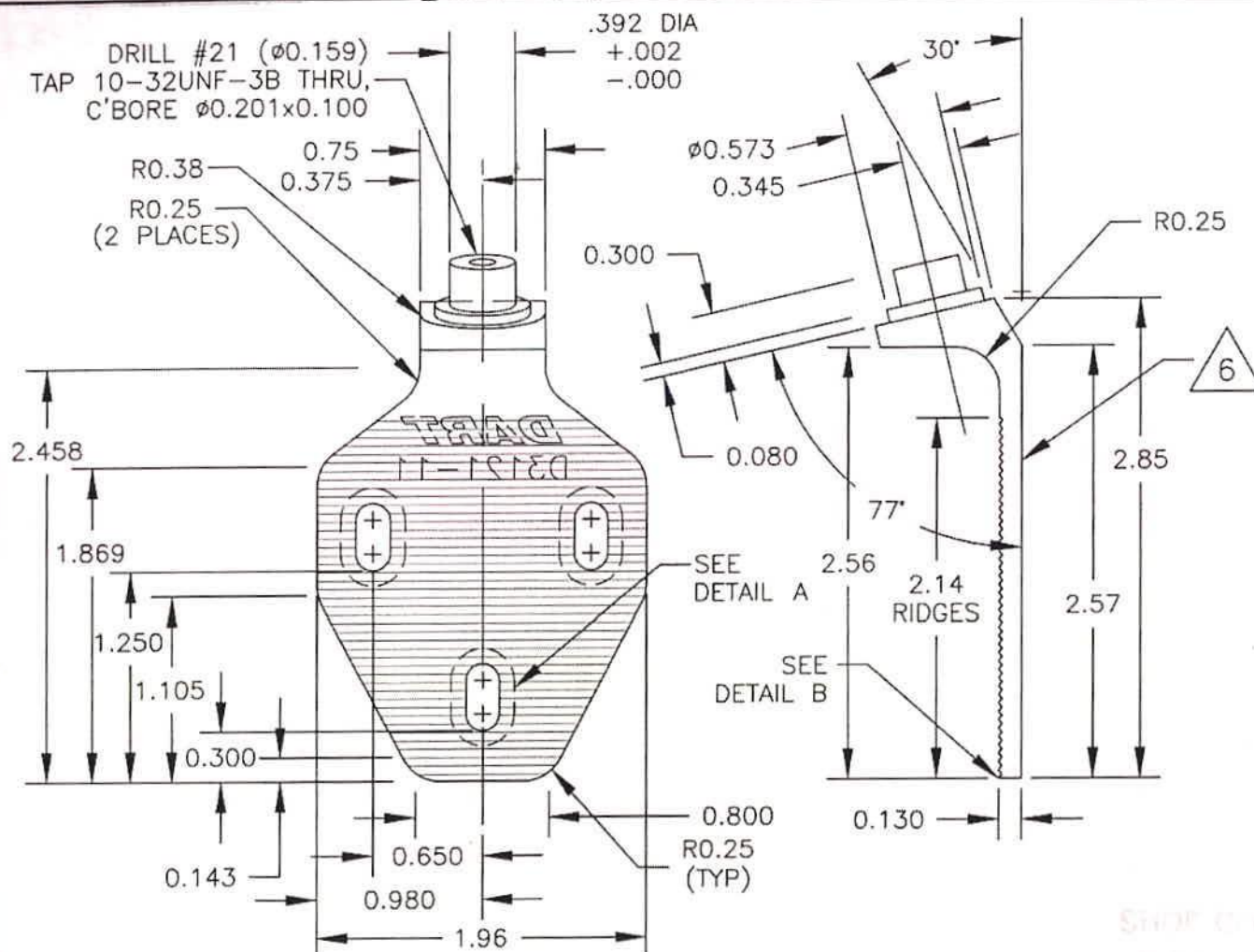
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DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:1

**D3121-11 BRACKET**

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)  
MIN ULTIMATE TENSILE = 150 ksi  
MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

WORK ORDER  
NO. 25225

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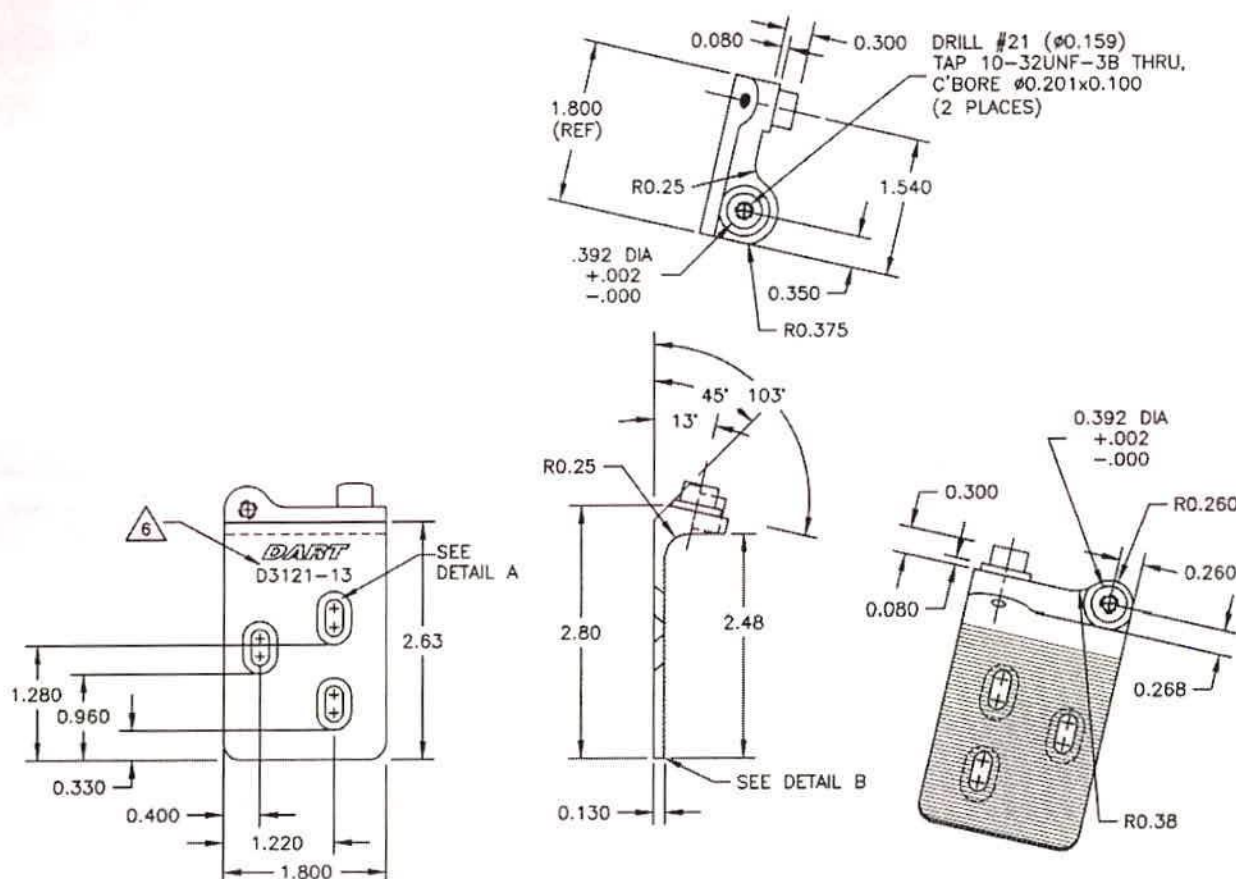
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DATE 04.02.18		TITLE BRACKET ASSEMBLY	SCALE 1:2



**D3121-13 BRACKET (SHOWN)**  
**D3121-14 BRACKET (OPPOSITE)**

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)  
MIN ULTIMATE TENSILE STRENGTH = 150 ksi  
MIN YIELD TENSILE STRENGTH = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

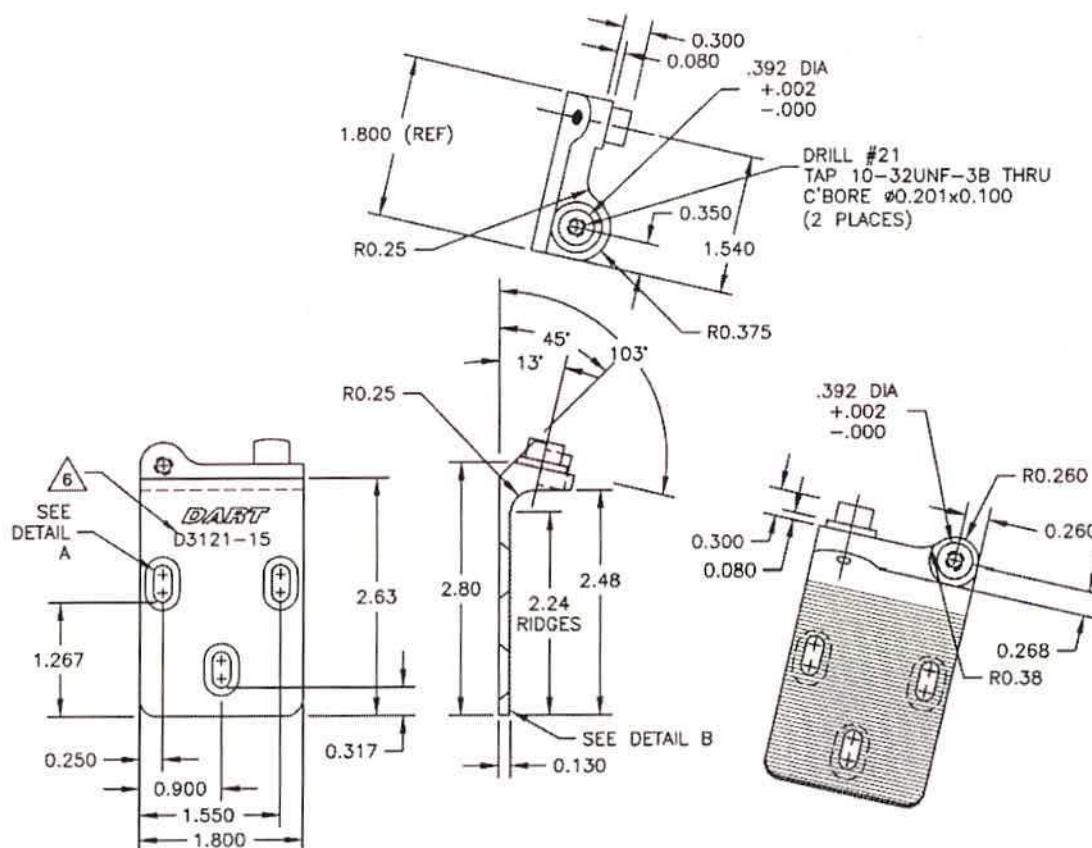
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DATE 04.02.18		TITLE BRACKET ASSEMBLY	SCALE 1:2

**D3121-15 BRACKET (SHOWN)****D3121-16 BRACKET (OPPOSITE)**

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)  
MIN ULTIMATE TENSILE = 150 ksi  
MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N AND LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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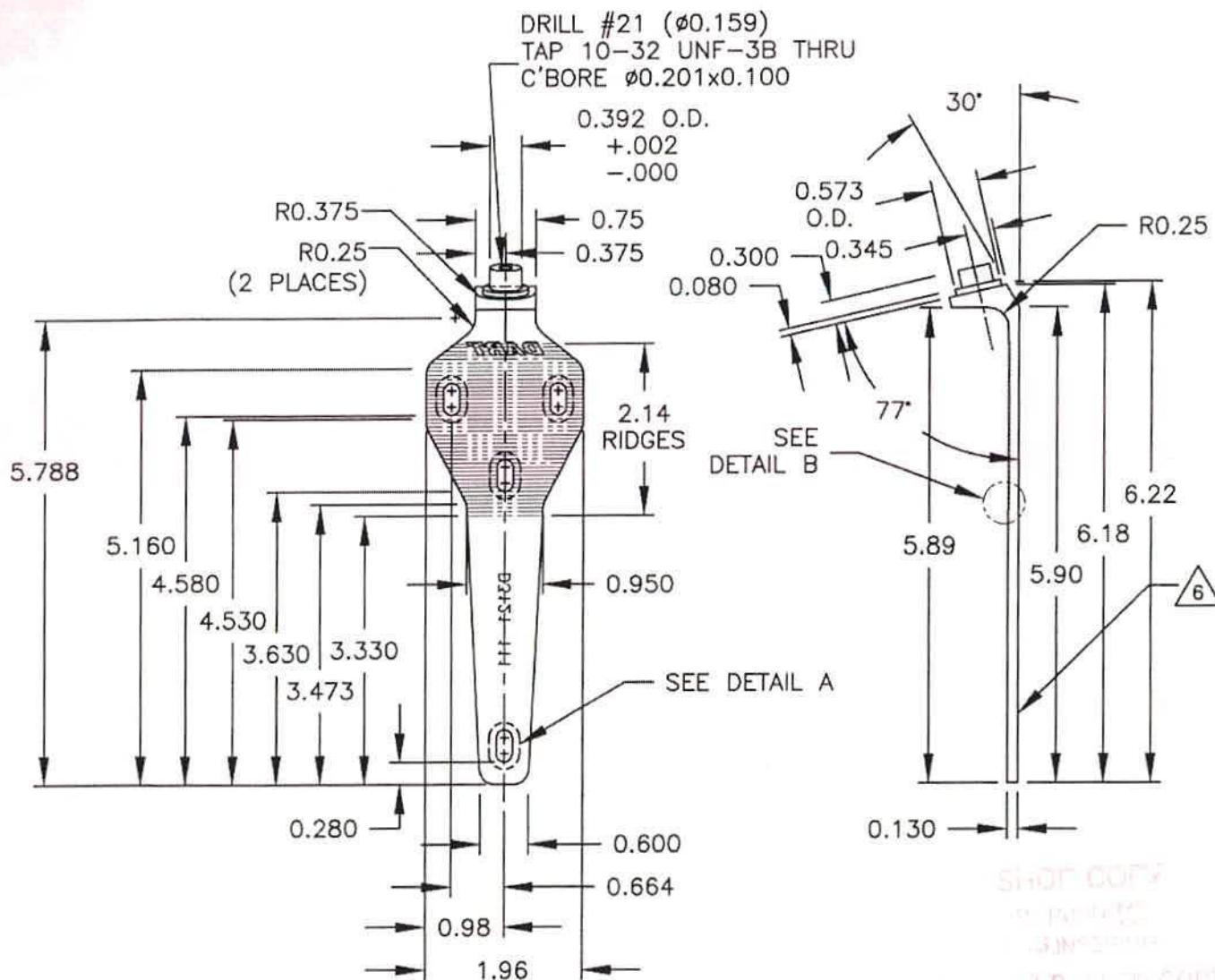
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DATE 04.02.18	TITLE BRACKET ASSEMBLY	REV. C SHEET 7 OF 10 SCALE 1:2

**D3121-111 BRACKET**

- 1) REPLACES PREMIER P/N B32-23001-11
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)  
MIN ULTIMATE TENSILE = 150 ksi  
MIN YIELD TENSILE = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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JAN 2018

17-4 SS COPY

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WORK ORDER

NO. 25225

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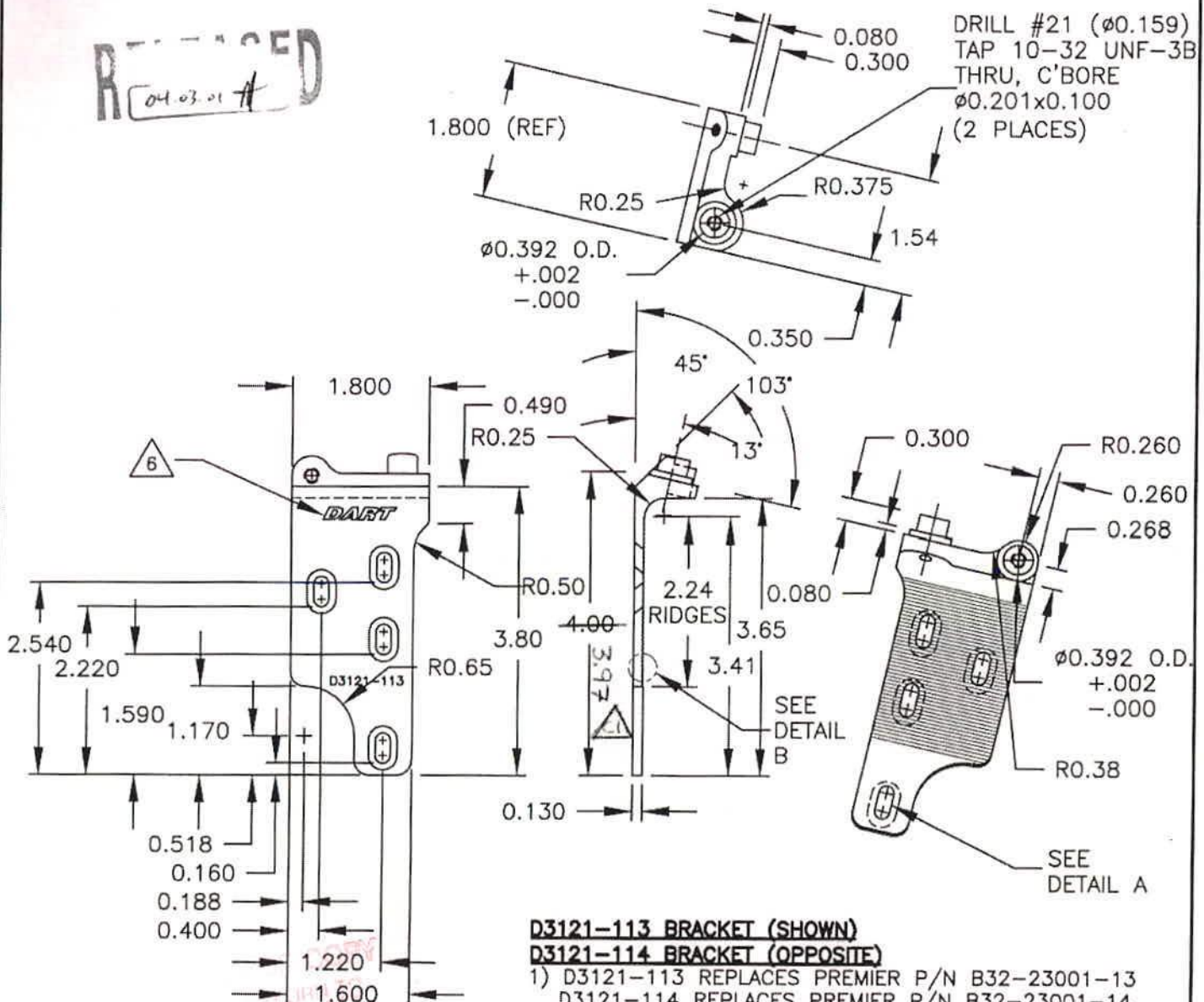
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DATE 04.02.18		TITLE BRACKET ASSEMBLY	SCALE 1:2

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#### D3121-113 BRACKET (SHOWN)

#### D3121-114 BRACKET (OPPOSITE)

- 1) D3121-113 REPLACES PREMIER P/N B32-23001-13  
D3121-114 REPLACES PREMIER P/N B32-23001-14
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643  
(REF DART SPEC. M17-4-B)  
MIN ULTIMATE TENSILE STRENGTH = 150 ksi  
MIN YIELD TENSILE STRENGTH = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

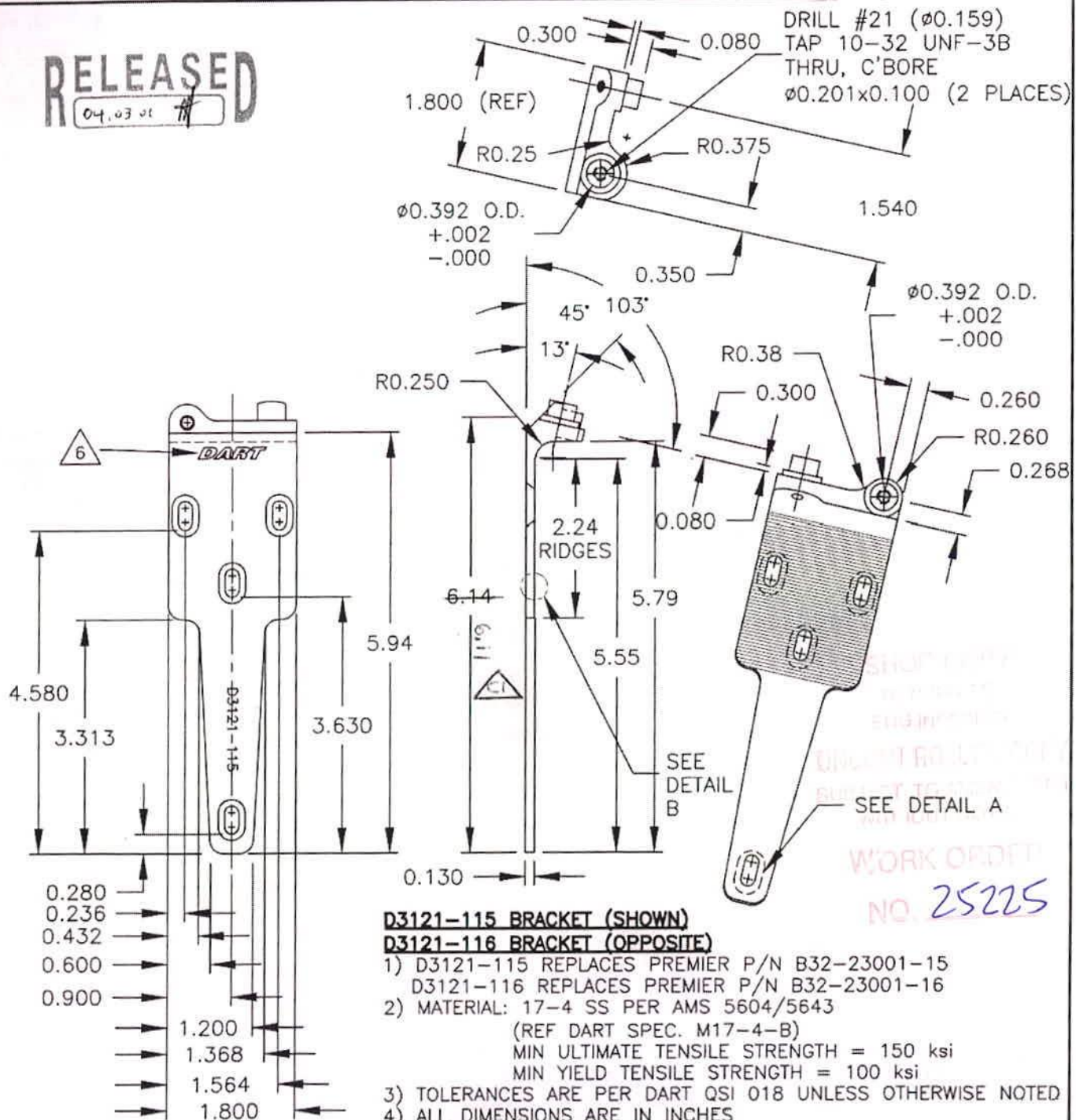
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DATE 04.02.18		TITLE BRACKET ASSEMBLY	SCALE 1:2

**RELEASED**  
04.03.01



**D3121-115 BRACKET (SHOWN)**  
**D3121-116 BRACKET (OPPOSITE)**

- 1) D3121-115 REPLACES PREMIER P/N B32-23001-15  
D3121-116 REPLACES PREMIER P/N B32-23001-16
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643  
(REF DART SPEC. M17-4-B)  
MIN ULTIMATE TENSILE STRENGTH = 150 ksi  
MIN YIELD TENSILE STRENGTH = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

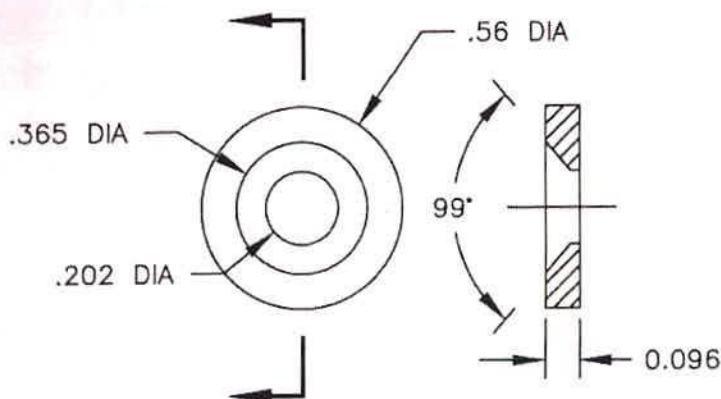
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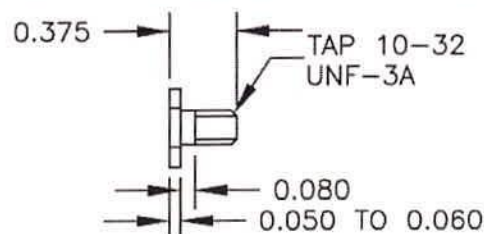


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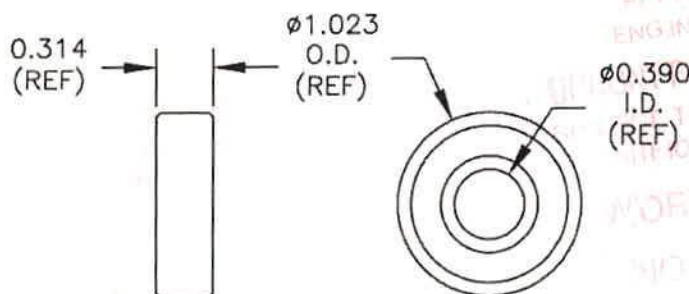
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DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:1

**D3121-17 WASHER (SCALE 2:1)**

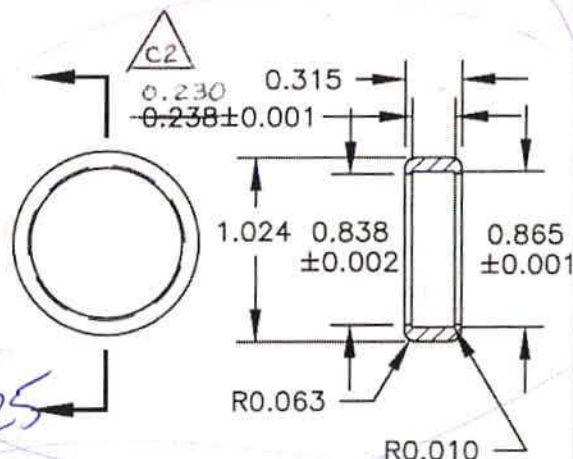
- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-21 BOLT (SCALE 1:1)**

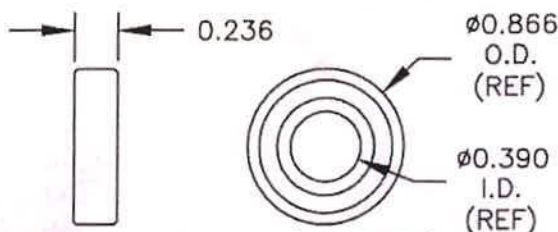
- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-19 BEARING (SCALE 1:1)**

- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES

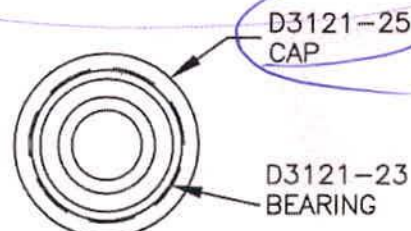
**D3121-25 CAP (SCALE 1:1)**

- 1) MATERIAL: DELRIN ROD, Ø1.25 (REF DART SPEC. M-DELIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

**D3121-23 BEARING (SCALE 1:1)**

- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z OR KML P/N 6900-2Z
- 2) ALL DIMENSIONS ARE IN INCHES

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**D3121-241 BEARING ASSEMBLY (SCALE 1:1)**

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